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54 **Process for producing branched alpha-olefin polymers.**

57 A process for homopolymerizing an α -olefin branched at the carbon atom of the third position or copolymerizing said α -olefin with another olefin in the presence of a catalyst system comprising a combination of an organo-aluminum compound and a solid catalyst component containing titanium, chlorine and a hydrocarbyloxy group, of which the X-ray diffraction spectrum has the diffraction lines at least corresponding to the diffraction lines of planes [113] and [300] of titanium trichloride having a layer structure and wherein the content of the hydrocarbyloxy group is 0.01 to 0.3 mole per 1 mole of titanium.

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PROCESS FOR PRODUCING BRANCHED α -OLEFIN POLYMERS

1 The present invention relates to a process for
producing a branched α -olefin polymer. It is known
that the melting point of ^{an}isotactic polymer of ^abranched
 α -olefin generally tends to increase when the degree of
5 branching increases and when the position of the branching
approaches the position of carbon-carbon double bond.
Accordingly, isotactic polymers of branched α -olefins and
particularly those having the branch at the carbon atom of
the third position are excellent in heat resistance and
10 useful as industrial material.

Like usual α -olefins, branched α -olefins can
also be polymerized with Ziegler catalysts. Unlike α -
olefins, however, in case of branched α -olefins, the
polymerization activity lowers extremely as compared with
15 that of α -olefins, and such low polymerizing
activity is particularly remarkable when the branch is
located on the carbon atom of the third position.

Various processes for polymerizing branched
 α -olefins were proposed in, for example, Japanese
20 Patent Application Kokai (Laid-Open) Nos. 59,989/76,
195,704/82, 182,305/82 and 8,708/83. However, when
branched α -olefins are polymerized by these processes, the
polymerization activity is still not sufficiently high.

The present inventors conducted elaborated studies
25 with the aim of finding a catalyst system showing a high

1 activity on the polymerization of branched α -olefins.

As the result, it was found that a catalyst system comprising a combination of an organo-aluminum compound and a solid catalyst component containing titanium,

5 chlorine and hydrocarbyloxy group shows a polymerization activity several times higher than that exhibited by the catalyst systems used in the above-mentioned known processes. Based on this finding, the present invention has been accomplished.

10 It is an object of this invention to provide a novel solid catalyst component for polymerizing branched α -olefins.

It is another object of this invention to provide a process for polymerizing branched α -olefins by using
15 the novel solid catalyst component.

Other objects and advantages of this invention will become apparent from the descriptions presented below.

According to this invention, there is provided a process for homopolymerizing an α -olefin branched at
20 the carbon atom of the third position or copolymerizing said α -olefin with another olefin in the presence of a catalyst system comprising a combination of an organo-aluminum compound and a solid catalyst component containing titanium, chlorine and ^ahydrocarbyloxy group, of which the
25 X-ray diffraction spectrum has the diffraction lines at least corresponding to the diffraction lines of planes [113] and [300] of titanium trichloride having a layer structure and of which ^{the}hydrocarbyloxy group content is

1 0.01 to 0.3 mole per 1 mole of titanium.

This invention is characterized in that, when an α -olefin branched at the carbon atom of the third position is polymerized by using the catalyst system of this invention, a polymerization activity of several times higher than that achievable in the known processes can be obtained.

The solid catalyst component containing titanium, chlorine and/^ahydrocarbyloxy group, provided by this invention gives an X-ray diffraction spectrum having diffraction lines at least corresponding to the diffraction lines of planes [113] and [300] of titanium trichloride having a layer structure, and contains 0.01 to 0.3 mole of/^ahydrocarbyloxy group per 1 mole of titanium.

15 The hydrocarbyloxy group is represented by the general formula OR^1 , wherein R^1 represents a hydrocarbon group having 1 to 20 carbon atoms. Concrete examples of R^1 include alkyl groups, such as methyl, ethyl, n-propyl, iso-propyl, n-butyl, iso-butyl, n-amyl, iso-amyl, n-hexyl, 20 n-heptyl, n-octyl, n-decyl, n-dodecyl and the like; aryl groups, such as phenyl, cresyl, xylyl, naphthyl and the like; cycloalkyl groups, such as cyclohexyl, cyclopentyl and the like; allyl groups, such as propenyl and the like; and aralkyl groups, such as benzyl and the like. Among them, 25 straight chain alkyl groups having 2 to 18 carbon atoms and aryl groups having 6 to 18 carbon atoms are particularly preferred. Said hydrocarbyloxy group may also be two or more kinds of different hydrocarbyloxy groups. The

1 content of the hydrocarbyloxy group in the solid catalyst
component is 0.01 to 0.3 mole and preferably 0.02 to 0.25
mole, per 1 mole of titanium.

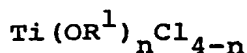
Further, the X-ray diffraction spectrum of
5 said solid catalyst component must have the diffraction
lines at least corresponding to the diffraction
lines of planes [113] and [300] of titanium trichloride
having a layer structure. As used herein, the term "titanium
trichloride having a layer structure" means the titanium
10 trichlorides mentioned in G. Natta et al.: J. Polymer
Sci., 51, 399 (1961), wherein the examples include ^{the} α -, γ -
and δ -form titanium trichlorides. The X-ray diffraction
spectrum of the solid catalyst component of this inven-
tion shows its diffraction lines at least at the lattice
15 spacing (d) of 2.72 - 2.52 Å and 1.78 - 1.76 Å. Preferably,
the solid catalyst component of this invention gives an
X-ray diffraction spectrum having diffraction lines at
least corresponding to the diffraction lines of planes
[113] and [300] of the δ -form titanium trichloride (d =
20 2.71 Å and 1.77 Å).

As examples of the synthetic procedure of such
a solid catalyst component, the following methods can be
illustrated.

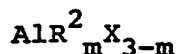
Synthetic Method (I)

25 This is a method which comprises reducing a
titanium compound represented by the following general
formula:

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- 1 wherein R^1 represents hydrocarbon group having 1 - 20 carbon atoms and n represents a numerical figure satisfying $0 < n \leq 4$, with an organo-aluminum compound represented by the following general formula:



- 5 wherein R^2 represents^a hydrocarbon group having 1 - 20 carbon atoms, X represents^a halogen atom and m represents a numerical figure satisfying $1 < m \leq 3$, to obtain a hydrocarbyloxy group-containing solid product insoluble in hydrocarbon solvents, followed by treating said solid
- 10 product with an ether compound and titanium tetrachloride in the state of a slurry at a temperature of 45°C to 120°C.
- In/^{the}Synthetic Method (1), R^1 in the titanium compound represented by the general formula $\text{Ti}(\text{OR}^1)_n\text{Cl}_{4-n}$ is a hydrocarbon group having 1 - 20 carbon atoms, and
- 15 preferably a straight chain alkyl group having 2 - 18 carbon atoms or an aryl group having 6 - 18 carbon atoms.

A good result can be obtained when n satisfies $0 < n \leq 4$ and particularly when n satisfies $1 \leq n \leq 4$.

- Concrete examples of the organo-aluminum com-
 20 pound represented by/^{the}general formula $\text{AlR}^2_m\text{X}_{3-m}$ (R^2 represents^a hydrocarbon group having 1 - 20 carbon atoms, X represents^a halogen atom, and m represents a numerical figure satisfying $1 < m \leq 3$), used in the reduction, include

1 ethylaluminum sesquichloride, dimethylaluminum chloride,
diethylaluminum chloride, di-n-propylaluminum chloride,
trimethylaluminum, triethylaluminum, tri-isobutylaluminum,
ethylidicyclohexylaluminum, triphenylaluminum, diethyl-
5 aluminum hydride, di-isobutylaluminum hydride, diethyl-
aluminum bromide, diethylaluminum iodide and the like.

Among them, diethylaluminum chloride and
ethylaluminum sesquichloride give particularly good
results.

10 The reduction is carried out preferably after
diluting the titanium compound and the organo-aluminum
compound to a concentration of 10 - 70% by weight with an
inert hydrocarbon solvent, such as pentane, hexane, heptane,
octane, decane, toluene or decalin.

15 The reaction temperature of the reduction is
-10°C to 80°C, and preferably 0°C to 70°C. Although ^{the} time
of the reduction is not critical, it is preferably 1 to
6 hours.

The molar ratio of the titanium compound to the
20 organo-aluminum compound can arbitrarily be varied
depending on the purpose. A good result can be obtained
by using 0.5 to 1.5 moles of diethylaluminum chloride or
1.5 to 2.5 moles of ethylaluminum sesquichloride per 1 mole
of the titanium compound. It is also allowable to carry
25 out after reaction at 30° to 100°C after completion of the
reduction.

The hydrocarbyloxy group-containing solid product
insoluble in hydrocarbon solvents, obtained by the reduction,

1 is separated from the liquid phase, washed several times
with an inert hydrocarbon solvent, such as pentane, hexane,
heptane, octane, decane, toluene, xylene, decalin or the
like, and then reacted with an ether compound and titanium
5 tetrachloride. As said ether compound, dialkyl ethers,
such as diethyl ether, di-n-propyl ether, di-isopropyl
ether, di-n-butyl ether, di-n-amyl ether, di-isoamyl ether,
di-neopentyl ether, di-n-hexyl ether, di-n-octyl ether,
methyl n-butyl ether, methyl isoamyl ether, ethyl isobutyl
10 ether and the like are preferable, among which di-n-butyl
ether and di-isoamyl ether are particularly preferred.
Said ether compound is used in an amount of 0.1 to 5 moles
and preferably 0.3 to 3 moles per 1 mole of the titanium
atom contained in the hydrocarbyloxy group-containing
15 solid product. The titanium tetrachloride is added in
an amount of 0.1 to 10 moles and preferably 0.5 to 5 moles
per 1 mole of the titanium atom contained in the solid
product. The ratio of the titanium tetrachloride to the
ether compound is 0.5 mole to 10 moles and preferably
20 1.5 moles to 5 moles per 1 mole of the ether compound.

The reaction among the hydrocarbyloxy group-
containing solid product insoluble in hydrocarbon solvents
and the ether compound and titanium tetrachloride is
carried out in the state of a slurry. As the solvent used
25 for making a slurry from the hydrocarbyloxy group-containing
solid product, aliphatic hydrocarbons, such as pentane,
hexane, heptane, octane, decane and the like, aromatic
hydrocarbons, such as toluene, xylene, decalin and the like

1 and alicyclic hydrocarbons, such as cyclohexane, methyl-
cyclohexane and the like can be referred to. The con-
centration of the slurry is 0.05 to 0.5 g-solid/ml-solvent,
and preferably 0.1 to 0.3 g-solid/ml-solvent. The reaction
5 temperature is 45° to 120°C and preferably 60° to 100°C.
Although the time of the reaction is not critical, it is
usually 30 minutes to 6 hours.

Addition of the solid product, the ether compound
and the titanium tetrachloride may be carried out by any
10 of the methods of adding the ether compound and titanium
tetrachloride to the solid product and the inverse method
of adding the solid product into a solution of the ether
compound and titanium tetrachloride. In the method of adding
the ether compound and titanium tetrachloride to the solid
15 product, the procedure of addition may be any of the
successive addition (addition of ether compound followed
by addition of titanium tetrachloride) and the simultaneous
addition of them.

The solid catalyst component obtained by the
20 above-mentioned reaction is separated from the liquid phase,
washed several times with an inert hydrocarbon solvent,
such as hexane, heptane or the like, and then used for
polymerization.

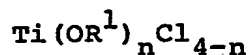
Synthetic Method (II)

25 This is a method which comprises reducing titanium
tetrachloride with an organo-aluminum compound represented
by the general formula $AlR_m^2X_{3-m}$ (R^2 , X and m are each as

1 defined previously), heat-treating the reduced product
at a temperature not higher than 150°C to obtain a heat-
treated solid product, reacting the heat-treated solid
product in a hydrocarbon solvent with a mixture comprising
5 a halogen compound represented by the following general
formula:



(X represents a halogen atom) and an ether compound, and
treating the reaction product with a titanium compound
represented by the following general formula:



10 (R^1 and n are each as defined previously).

The organo-aluminum compound represented by the
general formula $AlR^2_mX_{3-m}$ (R^2 , X and m are each as defined
previously) used in the reduction of this synthetic method
is the same as that used in ^{the} Synthetic Method (I). Par-
15 ticularly, ethylaluminum sesquichloride and diethylaluminum
chloride give good results.

The reduction is preferably carried out in an
inert hydrocarbon solvent, particularly aliphatic hydro-
carbon solvents such as hexane, heptane and the like,
20 at a temperature of -50°C to 50°C, particularly -30°C
to 30°C. Concretely saying, it is preferable to add a
solution of the organoaluminum compound in an inert

- 1 hydrocarbon to a solution of titanium tetrachloride in
an inert hydrocarbon so slowly as to maintain the system
at the predetermined temperature. The concentrations of
titanium tetrachloride and the organo-aluminum compound
5 in the inert hydrocarbon solution are both in the range of from
20 to 80% by weight and preferably in the range of ^{from} 30 to
60% by weight. The ratio of ^{the} organo-aluminum compound
represented by the general formula $AlR_m^2X_{3-m}$ to titanium
tetrachloride used in the reaction is m^{-1} to $2 \times (m-1)^{-1}$ mole
10 organo-aluminum compound and preferably $1 \times (m-1)^{-1}$ to
 $1.5 \times (m-1)^{-1}$ mole organo-aluminum compound, per 1 mole of
titanium tetrachloride. (Here, the molar number of organo-
aluminum compound is counted as a monomer.) Preferably,
the reduction is carried out with an appropriate stirring.
15 After mixing titanium tetrachloride with the organo-aluminum
compound, the system is preferably stirred at a temperature
falling in the above-mentioned reaction temperature range
for 15 minutes to 6 hours to complete the reduction. Thus,
a suspension of the reduced solid product is obtained.
20 The heat-treatment may be performed after
separating the reduced solid product from the suspension
formed by the reduction and then washing it with an inert
hydrocarbon solvent. More preferably, however, the heat-
treatment is carried out by directly using the suspension
25 of reduced solid product as it is. The heat-treatment can
be performed by heating the suspension of reduced solid
product at a temperature not higher than 150°C, preferably
at a temperature of 50° to 120°C. The optimum temperature

1 of the heat treatment varies depending on the kind of
organo-aluminum compound used in the reduction. For example,
the optimum temperature of heat treatment is 50° to 100°C
when the organo-aluminum compound is ethylaluminum
5 sesquichloride, and it is 75° to 110°C when the organo-
aluminum compound is diethylaluminum chloride. The time of
the heat treatment is usually ^{of} 15 minutes to 6 hours, and
^{of} preferably 30 minutes to 4 hours. After the heat treatment,
the solid product is separated from the liquid phase and
10 washed with an inert hydrocarbon solvent to obtain a heat-
treated solid product.

The halogen compound is represented by the general
formula X_2 , wherein X represents Cl, Br or I. Preferably,
X is I. The halogen compound is used in an amount of 10^{-5}
15 mole to 5×10^{-2} mole and preferably 10^{-4} mole to 10^{-2} mole,
per 1 g of the heat-treated solid product.

Preferably, the halogen compound is used in the
form of a solution in a hydrocarbon solvent and/or an ether
compound.

20 As said ether compound, the same one as in the
Synthetic Method (I) is used. Particularly preferred
ether compounds are di-n-butyl ether and di-isoamyl ether.
The ether compound is used in an amount of 10^{-4} mole to
0.03 mole, preferably 10^{-3} mole to 0.02 mole, and par-
25 ticularly preferably 0.002 mole to 0.01 mole, per 1 g of
the heat-treated solid product.

The reaction between the heat-treated solid
product and a mixture composed of the halogen compound

1 and the ether compound is carried out in a hydrocarbon solvent. Concrete examples of said hydrocarbon solvent include aliphatic hydrocarbons, such as hexane, heptane, octane, decane and the like and aromatic hydrocarbons such
5 as benzene, toluene, xylene and the like. The concentration of the heat-treated solid product in the hydrocarbon solvent is 50 to 500 g/liter and preferably 100 to 400 g/liter. The reaction temperature is 50° to 120°C and preferably 70° to 100°C. Preferably, the reaction is
10 carried out while stirring a suspension of ^{the} heat-treated solid product. The time of the reaction is preferably in the range of ^{from} 5 minutes to 6 hours, and particularly in the range of ^{from} 15 minutes to 2 hours.

After the reaction, the solid product is separated
15 from the liquid phase, washed with an inert hydrocarbon solvent and then treated with a titanium compound represented by the general formula $Ti(OR^1)_nCl_{4-n}$. Alternatively, without separating the solid product from the liquid phase the titanium compound represented by the general formula
20 $Ti(OR^1)_nCl_{4-n}$ is directly added to the reacted suspension and then a heat treatment is carried out. In the titanium compound represented by the above-mentioned general formula $Ti(OR^1)_nCl_{4-n}$ wherein R^1 represents ^ahydrocarbon group having 1 to 20 carbon atoms and n represents a numerical
25 figure satisfying $0 < n \leq 4$, R^1 is preferably a straight chain alkyl group having 2 to 18 carbon atoms or an aryl group having 6 to 18 carbon atoms. The numerical figure n must satisfy $0 < n \leq 4$ and preferably $0.2 \leq n \leq 2$.

1 The treatment with the titanium compound represented by
the general formula $Ti(OR^1)_nCl_{4-n}$ is carried out in a
hydrocarbon solvent. The concentration of $Ti(OR^1)_nCl_{4-n}$
is not lower than 5% by volume, and preferably 15 to 60%
5 by volume. The temperature of the treatment is 0° to
100°C, and preferably 40° to 80°C. The time of the treat-
ment is 5 minutes to 4 hours, and preferably 15 minutes
to 2 hours. The solid catalyst component obtained by the
above-mentioned reaction is separated from the liquid phase,
10 washed several times with an inert hydrocarbon solvent,
such as hexane, heptane or the like, and then used for
polymerization.

Next, as the organo-aluminum compounds usable
for the polymerization of olefins in this invention,
15 trialkylaluminums, dialkylaluminum hydrides, dialkyl-
aluminum chlorides, dialkylaluminum alkoxides, dialkyl-
aluminum siloxides and their mixtures can be referred to.
Examples of the preferably usable organo-aluminum compound
include dimethylaluminum chloride, diethylaluminum
20 chloride, di-isobutylaluminum chloride, diethylaluminum
bromide, diethylaluminum iodide, trimethylaluminum,
triethylaluminum, tri-isobutylaluminum, diethylaluminum
hydride, diethylaluminum ethoxide and mixtures thereof.
Among them, trimethylaluminum, triethylaluminum, tri-
25 isobutylaluminum, diethylaluminum ethoxide and mixtures
thereof are particularly preferred. The organo-aluminum
compound is used in an amount of 0.5 mole to 100 moles
and preferably 1 mole to 50 moles, per 1 mole of titanium

1 atom present in the solid catalyst component.

The branched α -olefins used in this invention are α -olefins branched at the carbon atom of the third position. Concrete examples of such branched α -olefin
5 include 3-methylbutene-1, 3-methylpentene-1, 3-ethylpentene-1, 3-methylhexene-1, 3,5-dimethylhexene-1, vinylcyclopentane, vinylcyclohexane, 4-vinylcyclohexene-1 and the like. Among these branched α -olefins, 3-methylbutene-1 and vinylcyclohexane are particularly preferred. The
10 scope of this invention involves not only the homopolymerization of the above-mentioned branched α -olefins, but also the copolymerization of the above-mentioned branched α -olefins and other olefins copolymerizable therewith. The "other olefins" usable for the copolymerization are
15 straight or branched chain α -olefins having 2 to 12 carbon atoms and straight chain internal olefins having 4 to 12 carbon atoms. Concrete examples ^{hereof} include ethylene, propylene, butene-1, pentene-1, hexene-1, octene-1, 4-methylpentene-1, 4-methylhexene-1, 5-methylhexene-1,
20 butene-2, pentene-2 and hexene-2.

The polymerization is carried out in the presence of an inert hydrocarbon such as hexane, heptane or the like as a diluent. Alternatively, the polymerization is carried out in the state of a slurry by using the liquid
25 monomer itself as a medium for the polymerization. The temperature of the polymerization is in the range of from 25° to 150°C. The polymerization is usually carried out under a pressure ranging from 1 atmosphere to about 50 atmospheres.

1 The mode of the polymerization may be any of/^acontinuous
system and batch system. Further, various electron-
donative compounds may also be added at the time of
polymerization for the purpose of improving the activity
5 of/^{the}catalyst and/^{the}stereospecificity. It is also allowable
to add a chain transfer agent, such as hydrogen or the
like for the purpose of regulating the molecular weight
of the polymer.

Next, the process of this invention will be
10 illustrated with reference to the following examples, but
the invention is not limited thereto.

Example 1

(A) Synthesis of Solid Product

After replacing, with argon, the inner atmosphere
15 of a flask having a capacity of 500 ml and/^{being}equipped with
a stirrer and a dropping funnel, 90 ml of n-heptane and
100.5 ml of tetra-n-butoxytitanium were charged into the
flask. While maintaining the inner temperature of the
flask at 35°C, a solution composed of 162 ml of n-heptane
20 and 67.2 ml of ethylaluminum sesquichloride was slowly
added dropwise into the flask from the dropping funnel
over a period of 2 hours. After dropping it, the inner
temperature was elevated to 60°C and the content of the
flask was stirred for one hour. The flask was allowed to
25 stand at room temperature and the reaction mixture was
separated into solid and liquid phases, after which the
solid product was washed four times with 100 ml of n-heptane

1 and dried under reduced pressure to obtain a red-brown
colored solid product. One gram of this solid product
contained 4.68 millimoles of titanium, 6.29 millimoles of
n-butoxy group and 0.23 millimole of aluminum, and the
5 ratio of n-butoxy group/titanium was 1.34 (by mole). In
the X-ray diffraction spectrum of this solid product
measured with Cu-K α rays, the characteristic peaks of
titanium trichloride crystal were not found at all.

(B) Synthesis of/^{the}Solid Catalyst Component

10 After replacing the inner atmosphere of a flask
having a capacity of 100 ml with argon, 6.95 g of the
solid product prepared in (A) above and 35 ml of n-heptane
were charged into the flask. While maintaining the inner
temperature of the flask at 75°C, 5.2 ml of di-n-butyl
15 ether and 6.8 ml of titanium tetrachloride were added and
reacted at this temperature for 1 hour. The flask was
allowed to stand at room temperature and the reaction
mixture was separated into solid and liquid phases, after
which the solid product was washed four times with 50 ml of
20 n-heptane and then dried under reduced pressure to obtain
~~a red-violet colored solid catalyst component.~~ One gram
of this solid catalyst component contained 5.91 millimoles
of titanium, 0.42 millimole of n-butoxy group and 0.01
millimole of aluminum, and the ratio n-butoxy group/
25 titanium was 0.071 (by mole). The X-ray diffraction
spectrum of this solid catalyst component had diffraction
lines corresponding to the diffraction lines of planes [113]
and [300] of/^{the} δ -form titanium trichloride.

1 (C) Polymerization of Vinylcyclohexane

After replacing, with argon, the inner atmosphere
of a flask having a capacity of 100 ml and/equipped with
a magnetic stirrer, 9.6 ml of n-heptane, 2.6 millimoles
5 of triethylaluminum, 98.4 mg of the solid catalyst component
obtained in (B) above and 5 ml of vinylcyclohexane were
added. The inner temperature of the flask was elevated to
50°C, and polymerization was carried out at this temper-
ature for one hour. For the sake of after-treatment, the
10 product was washed several times with 40 ml of a 1:9 (by
volume) mixture of hydrochloric acid (hydrogen chloride
content 36%) and methanol and then it was thoroughly washed
with water. Then, it was washed twice with 40 ml of
methanol, filtered and dried under reduced pressure to
15 obtain a granular polymer. Yield of the granular polymer
was 2.87 g. This means that the yield (g) of polyvinyl-
cyclohexane per 1 g of solid catalyst component (herein-
after, simply referred to as "Polym/Cat") was 29.2.

Comparative Example 1

20 Vinylcyclohexane was polymerized by repeating
the procedure of Example 1-(C), except that the solid
catalyst component obtained in Example 1-(B) was replaced
with 101.5 mg of a commercially available titanium tri-
chloride [this titanium trichloride had been prepared by
25 reducing TiCl_4 with organo-aluminum to obtain a complex
compound of TiCl_3 and AlCl_3 (molar ratio Ca. 3:1), treating
the complex with di-isoamyl ether to extract off the major

- 1 part of AlCl_3 and then activating the residue by a
treatment with TiCl_4 ; 1 g of this solid catalyst component
contained 6.05 millimoles of titanium and 0.16 millimole
of aluminum]. / yield of /granular polymer was 0.51 g, and
5 Polym/Cat was 5.0.

Example 2

- Vinylcyclohexane was polymerized by repeating
the procedure of Example 1-(C), except that the solid
catalyst component obtained in Example 1-(B) was used in
10 an amount of 90.2 mg and the triethylaluminum was replaced
with 2.6 millimoles of trimethylaluminum. / yield of /granular
polymer was 1.65 g, and Polym/Cat was 18.3.

Example 3

- Vinylcyclohexane was polymerized by repeating
15 the procedure of Example 1-(C), except that the solid
catalyst component obtained in Example 1-(B) was used in
an amount of 106.3 mg, the 2.6 millimoles of triethyl-
aluminum was replaced with a mixture consisting of 1.3
millimoles of triethylaluminum and 1.3 millimoles of
20 diethylaluminum ethoxide and the time of the polymerization
was 25 minutes. / yield of /granular polymer was 2.97 g,
and Polym/Cat was 27.9.

Example 4

- A violet-colored solid catalyst component was
25 prepared by repeating the procedure of Example 1-(B),

1 except that the reaction was carried out at 95°C for 2
hours by using 9.69 g of the solid product obtained in
Example 1-(A), 48.5 ml of n-heptane, 7.3 ml of di-n-butyl
ether and 23.6 ml of titanium tetrachloride. One gram
5 of this solid catalyst component contained 6.05 millimoles
of titanium, 0.15 millimole of n-butoxy group and 0.01
millimole of aluminum, and its n-butoxy group/titanium
ratio was 0.025 (by mole). The X-ray diffraction spectrum
of this solid catalyst component had diffraction lines
10 corresponding to the diffraction lines of planes [113] and
[300] of ^{the}δ-form titanium trichloride.

Then, vinylcyclohexane was polymerized by
repeating the procedure of Example 1-(C), except that
this solid catalyst component was used in an amount of
15 87.9 mg. ^{The}Yield of ^{the}granular polymer was 1.15 g, and
Polym/Cat was 13.1.

Example 5

A solid catalyst component was prepared by
repeating the procedure of Example 1-(B), except that the
20 reaction was carried out at 70°C for one hour by using
11.41 g of the solid product obtained in Example 1-(A),
57.1 mg of n-heptane, 8.5 ml of di-n-butyl ether and 8.3 ml
of titanium tetrachloride. One gram of this solid
catalyst component contained 5.41 millimoles of titanium,
25 1.18 millimoles of n-butoxy group and 0.02 millimole of
aluminum, and its n-butoxy group/titanium ratio was 0.218
(by mole). The X-ray diffraction spectrum of this solid

- 1 catalyst component had diffraction lines corresponding
to the diffraction lines of planes [113] and [300] of
δ-form titanium trichloride. Then, vinylcyclohexane was
polymerized by repeating the procedure of Example 1-(C),
5 except that 94.7 mg of this solid catalyst component was
used. ^{The} ^{the} / yield of/ granular polymer was 1.16 g, and Polym/Cat
was 12.2.

Comparative Example 2

- A solid catalyst component was prepared by
10 repeating the procedure of Example 1-(B), except that the
reaction was carried out at 100°C for one hour by using
4.42 g of the solid product obtained in Example 1-(A) and
20 ml of titanium tetrachloride and using neither n-heptane
nor di-n-butyl ether. One gram of this solid catalyst
15 component contained 5.85 millimoles of titanium, 0.22
millimole of n-butoxy group and 0.18 millimole of aluminum,
and its n-butoxy group/titanium ratio was 0.038 (by mole).
The X-ray diffraction spectrum of this solid catalyst
component had the same diffraction lines as those of β-form
20 titanium trichloride having a fibriform structure.

- Then, vinylcyclohexane was polymerized by
repeating the procedure of Example 1-(C), except that
107.4 mg of this solid catalyst component was used. ^{The} / yield
of the granular polymer was 0.44 g, and Polym/Cat was
25 4.1.

1 Comparative Example 3

A solid catalyst component was prepared by repeating the procedure of Example 1-(B), except that the reaction was carried out at 90°C for one hour by using
5 6.62 g of the solid product obtained in Example 1-(A), 33.1 ml of n-heptane and 9.7 ml of titanium tetrachloride and using no di-n-butyl ether. One gram of this solid catalyst component contained 5.36 millimoles of titanium, 2.11 millimoles of n-butoxy group and 0.17 millimole of
10 aluminum, and its n-butoxy group/titanium ratio was 0.394 (by mole). In the X-ray diffraction spectrum of this solid catalyst component, the characteristic peaks of titanium trichloride crystal were not found at all. Then, vinylcyclohexane was polymerized by repeating the procedure of
15 Example 1-(C), except that 98.0 mg of this solid catalyst component was used. As the result, no granular polymer was formed at all.

Comparative Example 4

Vinylcyclohexane was polymerized by repeating
20 the procedure of Example 1-(C), except that the solid product obtained in Example 1-(A) was used in an amount of 81.2 mg. As the result, no granular polymer was formed at all.

Example 6

the
(A) Synthesis of/Solid Product

25 After replacing, with argon, the inner atmosphere

- 1 of a flask having a capacity of 500 ml and ^{being}/equipped with
a stirrer and a dropping funnel, 100 g of tetra-o-cresoxy-
titanium and 250 ml of toluene were charged into the flask
and the tetra-o-cresoxytitanium was dissolved. Then,
5 while maintaining the inner temperature of the flask at
60°C, a solution composed of 100 ml of toluene and 47.8 ml
of ethylaluminum sesquichloride was slowly added dropwise
thereinto from the dropping funnel over a period of 2
hours. After dropping it, the content of the flask was
10 stirred at 60°C for one hour. Then, the flask was allowed
to stand at room temperature and the reaction mixture was
separated into solid and liquid phases, after which the
solid product was washed four times with 200 ml of n-
heptane and dried under reduced pressure to obtain a brown-
15 colored solid product. One gram of this solid product
contained 3.8 millimoles of titanium and 4.7 millimoles of
o-cresoxy group. In the X-ray diffraction spectrum of
this solid product measured with Cu-K α rays, no characteris-
tic peaks of titanium trichloride crystal were found at all.
20 (B) Synthesis of ^{the}/Solid Catalyst Component .

After replacing the inner atmosphere of a flask
having a capacity of 100 ml with argon, 6.3 g of the
solid product synthesized in (A) above and 32 ml of n-
heptane were charged into the flask and the inner temper-
25 ature of the flask was maintained at 30°C. Then, 5.7 ml
of di-isoamyl ether was added and treated at 35°C for
one hour. Subsequently, 6.2 ml of titanium tetrachloride
was added, the temperature was elevated to 65°C, and

1 the content of the flask was reacted at 65°C for one hour.
The flask was allowed to stand at room temperature and the
reaction mixture was separated into solid and liquid
phases, after which the solid product was washed five
5 times with 50 ml of n-heptane and dried under reduced
pressure to obtain a solid catalyst component.

One gram of this solid catalyst component contained
5.3 millimoles of titanium, 0.19 millimole of o-cresoxy
group and 0.02 millimole of aluminum, and its o-cresoxy
10 group/titanium ratio was 0.036 (by mole). The X-ray dif-
fraction spectrum of this solid catalyst component had
diffraction lines corresponding to the diffraction lines
of planes [113] and [300] of ^{the}δ-form titanium trichloride.

(C) Polymerization of Vinylcyclohexane

15 Vinylcyclohexane was polymerized by repeating
the procedure of Example 1-(C), except that 75.4 mg of
the solid catalyst component obtained in (B) above was used.
As the result, ^{the} yield of ^{the} granular polymer was 1.83 g, and
Polym/Cat was 24.3.

20 Example 7

(A) Synthesis of ^{the} Solid Product

After replacing, with argon, the inner atmosphere
of a flask having a capacity of 300 ml and ^{being} equipped with
a stirrer and a dropping funnel, 15 ml of n-heptane and
25 15 ml of titanium tetrachloride were charged into the
flask, and the inner temperature of the flask was maintained
at 80°C. Then, while maintaining the inner temperature of

1 the flask at 80°C, a solution composed of 40 ml of n-heptane
and 52 ml of n-decyl alcohol was slowly added dropwise
thereinto from the dropping funnel over a period of one
hour. After dropping it, the content of the flask was
5 stirred at 80°C for 1.5 hours. After lowering the inner
temperature of the flask to 50°C, a solution composed of
40 ml of n-heptane and 17 ml of diethylaluminum chloride
was slowly added dropwise thereinto from the dropping
funnel over a period of 2 hours, while maintaining the
10 inner temperature of the flask at 50°C. After dropping it,
the temperature was elevated to 60°C, and the content of
the flask was stirred for one hour. The flask was allowed
to stand at room temperature and the reaction mixture
was separated into solid and liquid phases, after which
15 the solid product was washed six times with 100 ml of
n-heptane and dried under reduced pressure to obtain a
brown-colored solid product.

(B) Synthesis of ^{the}/Solid Catalyst Component

A solid catalyst component was prepared by
20 repeating the procedure of Example 1-(B), except that
6.75 g of the solid product obtained in (A) above, 24 ml of
n-heptane, 10 ml of monochlorobenzene, 4.1 ml of di-n-butyl
ether and 5.4 ml of titanium tetrachloride were used. One
gram of this solid catalyst component contained 5.1 milli-
25 moles of titanium, 0.17 millimole of n-decylalkoxy group
and 0.02 millimole of aluminum, and the n-decylalkoxy
group/titanium ratio was 0.033 (by mole). The X-ray dif-
fraction spectrum of this solid catalyst component had

- 1 diffraction lines corresponding to the diffraction lines
of planes [113] and [300] of ^{the} δ -form titanium trichloride.

(C) Polymerization of Vinylcyclohexane

- Vinylcyclohexane was polymerized by repeating
5 the procedure of Example 1-(C), except that 131.1 mg
of the solid catalyst component obtained in (B) above was
used and the time of the polymerization was 25 minutes. The
yield of ^{the} granular polymer was 1.94 g, and Polym/Cat was
14.8.

10 Example 8

(A) Synthesis of ^{the} Heat-treated Solid Product

- After replacing, with argon, the inner atmosphere
of a four-necked flask having a capacity of 500 ml and
equipped with a stirrer and a dropping funnel, 114 ml
15 of n-heptane and 30 ml of titanium tetrachloride were
charged into the flask and ^{the} temperature of the resulting
solution was maintained at -10°C . Then, while maintaining
the inner temperature of the flask at -5°C to -10°C , a
solution composed of 150 ml of n-heptane and 68.3 ml of
20 ethylaluminum sesquichloride was added dropwise thereinto
from the dropping funnel over a period of 2 hours. After
dropping it, the content of the flask was stirred at
room temperature for 30 minutes. Then, the temperature
was elevated to 65°C , and a heat-treatment was carried at
25 this temperature for 2 hours. Then, the flask was allowed
to stand at room temperature and the reaction mixture
was separated into solid and liquid phases, after which

1 the solid product was washed four times with 200 ml of
n-heptane and dried under reduced pressure to obtain a
heat-treated solid product.

(B) Synthesis of/^{the}Solid Catalyst Component

5 After replacing, with argon, the inner atmosphere
of a flask having a capacity of 200 ml and/^{being}equipped with
a stirrer, 91.5 ml of n-heptane, 24.0 ml of di-isoamyl
ether and 3.0 g of iodine were charged into the flask, and
the iodine was dissolved at 50°C for 30 minutes. Then,
10 18.3 g of the heat-treated solid product obtained in (A)
above was charged into the flask and reacted at 95°C for
one hour. After the reaction, the reaction mixture was
cooled to 65°C, 30 ml of a titanium compound represented
by $\text{Ti}(\text{OBu})_{0.5}\text{Cl}_{3.5}$ was added, and the reaction mixture
15 was treated at 65°C for 30 minutes. Then, the flask was
allowed to stand at room temperature and the reaction
mixture was separated into solid and liquid phases, after
which the solid product was washed five times with 50 ml
of n-heptane and dried under reduced pressure to obtain
20 a violet-colored solid catalyst component. One gram of
this solid catalyst component contained 5.8 millimoles of
titanium, 0.21 millimole of n-butoxy group and 0.41 milli-
mole of aluminum, and its n-butoxy group/titanium ratio
was 0.036 (by mole). The X-ray diffraction spectrum of
25 this solid catalyst component had diffraction lines cor-
responding to the diffraction lines of planes [003], [113]
and [300] of/^{the} δ -form titanium trichloride.

1 (C) Polymerization of Vinylcyclohexane

Vinylcyclohexane was polymerized by repeating the procedure of Example 1-(C), except that 95.8 mg of the solid catalyst component obtained in (B) above was used.

5 As the result, ^{the}yield of ^{the}granular polymer was 2.53 g, and Polym/Cat was 26.4.

WHAT IS CLAIMED IS:

1. A process for homopolymerizing an α -olefin branched at the carbon atom of the third position or copolymerizing said α -olefin with another olefin in the presence of a catalyst system comprising a combination of an organo-aluminum compound and a solid catalyst component containing titanium, chlorine and ^ahydrocarbyloxy group, of which ^{the} x-ray diffraction spectrum has diffraction lines at least corresponding to the diffraction lines of planes [113] and [300] of titanium trichloride having a layer structure and wherein the content of the hydrocarbyloxy group is 0.01 mole to 0.3 mole per 1 mole of titanium.

2. A process according to Claim 1, wherein said hydrocarbyloxy group is represented by the following general formula:



wherein R^1 represents ^ahydrocarbon group having 1 to 20 carbon atoms.

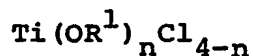
3. A process according to Claim 2, wherein R^1 in the general formula OR^1 is a straight chain alkyl group having 2 to 18 carbon atoms or an aryl group having 6 to 18 carbon atoms.

4. A process according to Claim 1, wherein the content of the hydrocarbyloxy group is 0.02 mole to 0.25 mole per 1 mole of titanium.

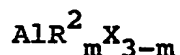
5. A process according to Claim 1, wherein the

X-ray diffraction spectrum of said solid catalyst component has diffraction lines at least corresponding to the diffraction lines of planes [113] and [300] of ^{the} δ -form titanium trichloride.

6. A process according to Claim 1, wherein said solid catalyst component is a solid catalyst component synthesized by reducing a titanium compound represented by the following general formula:



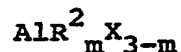
wherein R^1 represents ^ahydrocarbon group having 1 to 20 carbon atoms and n represents a numerical figure satisfying $0 < n \leq 4$, with an organo-aluminum compound represented by the following general formula:



wherein R^2 represents ^ahydrocarbon group having 1 to 20 carbon atoms, X represents ^ahalogen atom and m represents a numerical figure satisfying $1 < m \leq 3$, to obtain a hydrocarbyloxy group-containing solid product insoluble in hydrocarbon solvents, followed by treating said solid product at a temperature of 45°C to 120°C in the presence of an ether compound and titanium tetrachloride in the state of a slurry.

7. A process according to Claim 1, wherein said solid catalyst component is a solid catalyst component synthesized by reducing titanium tetrachloride with an organo-aluminum compound represented by the following

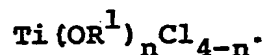
general formula:



wherein R^2 , X and m are each as defined above, followed by heat-treating the reduced product at a temperature not higher than 150°C, reacting the heat-treated product with a mixture consisting of a halogen compound represented by the following general formula:



wherein X represents ^a/halogen atom, and an ether compound in a hydrocarbon solvent, and then treating the reaction product with a titanium compound represented by the following general formula:



wherein R^1 and n are each as defined above.

8. A process according to Claim 1, wherein the organo-aluminum compound used for the polymerization is trialkylaluminum, dialkylaluminum hydride, dialkylaluminum chloride, dialkylaluminum alkoxide, dialkylaluminum siloxide or a mixture thereof.

9. A process according to Claim 8, wherein the organo-aluminum compound is trimethylaluminum, triethylaluminum, triisobutylaluminum, diethylaluminum ethoxide or a mixture thereof.

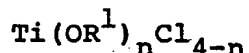
10. A process according to Claim 1, wherein the organo-aluminum compound used for the polymerization is used in

an amount ranging from 0.5 mole to 100 moles per 1 mole of titanium atom present in the solid catalyst component.

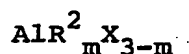
11. A process according to Claim 1, wherein said α -olefin branched at the carbon atom of the third position is 3-methylbutene-1 or vinylcyclohexane.

12. A process according to Claim 1, wherein the temperature of the polymerization is in the range of from 25° to 150°C.

13. A solid catalyst component synthesized by reducing a titanium compound represented by the following general formula:

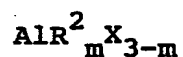


wherein R^1 represents/a hydrocarbon group having 1 to 20 carbon atoms and n represents a numerical figure satisfying $0 < n \leq 4$, with an organo-aluminum compound represented by the following general formula:



wherein R^2 represents/a hydrocarbon group having 1 to 20 carbon atoms, X represents/a halogen atom and m represents a numerical figure satisfying $1 < m \leq 3$, to obtain a hydrocarbyloxy group-containing solid product insoluble in hydrocarbon solvents, followed by treating said solid product at a temperature of 45°C to 120°C in the presence of an ether compound and titanium tetrachloride in the state of a slurry.

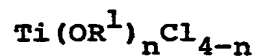
14. A solid catalyst component synthesized by reducing titanium tetrachloride with an organo-aluminum compound represented by the following general formula:



wherein R^2 , X and m are each as defined above, followed by heat-treating the reduced product at a temperature not higher than 150°C , reacting the heat-treated product with a mixture comprising a halogen compound represented by the general formula:



wherein X represents a halogen atom, and an ether compound in a hydrocarbon solvent, and then treating the reaction product with a titanium compound represented by the following general formula:



wherein R^1 and n are each as defined above.